

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 74.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028721**Date Inspected:** 07-Nov-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 530**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** Goodwin Steel, UK**Location:** Stoke-On-Trent, UK**CWI Name:****CWI Present:****Yes No****Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Type B16 Supplemental Cable Bands after proof**Summary of Items Observed:**

The Quality Assurance (QA) Inspector Shailesh Wadkar, arrived at Goodwin Steel Castings to observe the surface Non Destructive Testing (NDT), defect excavation & repair of Type B16 Supplemental Cable Bands after proof machining. The manufacturing of the additional Type B16 Supplemental Cable Bands at the foundry is as part of a risk management strategy to address the concern with certain cable band gaps closing up as the work is progressing on-site during the main cable load transfer to the orthotropic box girders. The following items observed on this date were:

Repair welding is in progress for Clamp ID No: GG37014-5. Welder was identified as Mr. Wayne Fradley and the welding process was identified as Shielded Metal Arc Welding (SMAW). Welding was observed to be done in 1G position. Welding was done as per welding procedure specification (WPS): WPS04-0120F4A Issue-5.

Repair welding is in progress for Clamp ID No: GG37015-9. Welder was identified as Mr. James Walker and the welding process was identified as SMAW. Welding was observed to be done in 1G position. Welding was done as per WPS: WPS04-0120F4A Issue-5.

This QA Inspector observed that the pre-heating and interpass temperature was maintained as per WPS requirement; while the welding was in progress. Also proper interpass cleaning followed by interpass visual inspection was done before depositing the following run. See attached photos for details.

This QA Inspector performed random visual inspection of the completed welds and were observed free from any surface discontinuities.

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Repair welding of clamps ID Nos: GG37015-7 & 8 was observed to be completed.

Had a discussion with Mr. Adrian Murphy (Goodwin QA Co-ordinator) & it was understood that the Certified Welding Inspector (CWI) is scheduled to visit Goodwin on 8th Nov 2012 for the visual inspection of the completed weld repairs.



### Summary of Conversations:

Except as noted above, only general conversations between this QA Inspector and Goodwin International personnel relevant to the dimensional layout & machining of the Type B16 cable bands on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas, 916-764-6027, who represents the Office of Structural Materials for your project.

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**Inspected By:** Wadkar,Shailesh

Quality Assurance Inspector

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**Reviewed By:** Foerder,Mike

QA Reviewer